

642-412 BL

Blue

Dart Aerospace Ltd.

Date: Monday, 17/11/2008 10:36:56 AM  
 User: Julie Dawson

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : 206 L HIGH GEAR SKIDTUBE  
 Job Number : 43468A  
 Estimate Number : 10522  
 P.O. Number :  
 This Issue : 17/11/2008 S.O. No. :  
 Prsht Rev. : NC  
 First Issue : / / Type : SKIDTUBES  
 Previous Run : 41733A  
 Written By :  
 Checked & Approved By : JUD 08.11.17  
 Comment : Est Rev: H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM  
 Est Rev: I 08-05-01 add QC3 DD verified by: EC

Part Number : D206642441  
 Drawing Number : D2650 REV E  
 Project Number :  
 Drawing Revision : E  
 Material :  
 Due Date slip 10/01/2009 Qty: 1 Um: Each

## Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 DC DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

2.0 D2620 Skidtube, 206 Skidtube



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2620 Bent Tube 3" OD 42769

Job 8-11-18

3.0 D2647 Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2647 Fwd Cap 35475

BE 8-11-18

4.0 SKIDTUBES 1 SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Deburr Fwd edge of tube

Job 8-11-18

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R Aluminum Rod M109813/M109213 BE 8-11-18

4-Grind weld flush to cap on top surface only.

BE 8-11-18

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries

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## Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to  $\varnothing 0.312$ ".

7-Drill holes for wearplates using DT 8028-7. Open to  $\varnothing 0.297$ ".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to  $\varnothing 0.625$ " as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtube as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

J08-11-19

SL 8-11-20

5.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SL 8-11-20

6.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

a.m. 08-11-21 (1)

7.0

D26547

Web



Comment: Qty.: 1.0000 Each(s)/Unit Total: 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2654-7

Web

43665

SL 8-11-23

8.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail (without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015 Ensure holes line up Allow 12 Hrs. cure time before cutting

Start Date: 8-11-23 Time: 3pm

Finish Date: 08-11-24 Time: 7AM

SL 8-11-23

SL 8-11-22

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

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Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

A/R Sikaflex-291

Sikaflex expiry date:

109883

9-7-1

SL 8-11-23

9.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

10.0

D2649

Cross Bolt Spacer



Comment: Qty.: 23.0000 Each(s)/Unit Total : 23.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

23 D2649

Crossbolt spacer

243505

BE 08-11-24

11.0

SKIDTUBES 1

SKIDTUBESS RESOURCE 1



Comment: LANDING GEAR RESOURCE 1

1-Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.

A/R Aluminum Rod

M1092K3

BE 08-11-24

2-Grind welds flush as per Dwg D2650. Masking Tape access to inside of the Skidtube

JD 8-11-24

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Debur

JD 8-11-25

12.0

D2680041

Nut Plate



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2680-041

Nut Plate

34599

JD 8-11-25

13.0

CCR264SS33

Cherry Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total : 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 CCR264SS3-3

Rivets

109431

JD 8-11-25

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                           |                       |                          | Sign &<br>Date |
|      |      |                                  |                                |                                 |                           |                       |                          |                |
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Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #: Machine Or Operation: Description :

14.0 M7885343 Rivet



Comment: Qty.: 2.0000 Each(s)/Unit Total: 2.0000 Each(s)

Pick:

Qty Part Number

Description Batch

2 M7885/3-4-3

Rivets 106167

Jb 8-11-25

15.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Install D2680-041 Nut Plate as per Dwg D2650

Jb 8-11-25

16.0 QC10 VISUAL INSPECTION OF GROUND WELDS



Comment: VISUAL INSPECTION OF GROUND WELDS

8/11/27 (X)

17.0 QC5 INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

8/11/27 (X)

18.0 HAND FINISHING1 HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Pressure wash as per QSI 005

+ Touch-up Alodine

ml 08-11-28 (X)

19.0 SPRAY PAINTING SPRAY PAINTING



Comment:

-PRIME GREY

B 110199

-SPRAY PAINT DELFLEET BLUE

B 110077

-CLEAR DELFLEET

B 110161

ET 08-12-18

20.0 QC14 INSPECT SPRAY PAINT



Comment: INSPECT SPRAY PAINT

ml 08 12 19

(1)

21.0 D26483 Wearpad



Comment: Qty.: 6.0000 Each(s)/Unit Total: 6.0000 Each(s)

Pick:

Qty Part Number

Description Batch

6 D2648-3

Wearpad

B 42770 (3X)  
B 43802 (3X) M-1 08/12/23

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

22.0

D265615

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-15

Wearshoe \_\_\_\_\_

B41125 M-L

23.0

D265623

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-23

Wearshoe \_\_\_\_\_

B41822 M-L

24.0

D265637

Wearshoe



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D2656-37

Wearshoe \_\_\_\_\_

B43285 M-L

25.0

D34291

Wearpad



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 D3429-1

Wearpad \_\_\_\_\_

B42779 M-L

26.0

ALS41032130

Insert



Comment: Qty.: 60.0000 Each(s)/Unit Total : 60.0000 Each(s)

Pick:

Qty Part Number

Description Batch

60 ALS4-1032-130

Inserts \_\_\_\_\_

or (see QSI 017)

M106819

M-L 08/12/23

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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| DATE | STEP | Description of NC<br>Section A   | Corrective Action Section B |                                 |                | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng        | Action Description<br>Chief Eng | Sign &<br>Date |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |
|      |      |                                  |                             |                                 |                |                           |                       |                          |

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## Process Sheet

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Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43468A

Part Number: D206642441

Job Number:



| Seq. #: | Machine Or Operation: | Description : |
|---------|-----------------------|---------------|
|---------|-----------------------|---------------|

|      |            |        |
|------|------------|--------|
| 27.0 | AN960JD10L | Washer |
|------|------------|--------|



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 60  | AN960JD10L  | Washer      |       |

M105793

M-L

|      |            |       |
|------|------------|-------|
| 28.0 | MS27039108 | Screw |
|------|------------|-------|



Comment: Qty.: 62.0000 Each(s)/Unit Total : 62.0000 Each(s)

Pick:

| Qty | Part Number  | Description | Batch |
|-----|--------------|-------------|-------|
| 62  | MS27039-1-08 | Screw       |       |

M108077

(16X)

\* M109061

(46X)

M-L

|      |        |      |
|------|--------|------|
| 29.0 | D26511 | Plug |
|------|--------|------|



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 22  | D2651-1     | BLUE Plugs  |       |

B43382

M-L

|      |        |        |
|------|--------|--------|
| 30.0 | D26513 | O-Ring |
|------|--------|--------|



Comment: Qty.: 22.0000 Each(s)/Unit Total : 22.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 22  | D2651-3     | O-Rings     |       |

B41972

M-L

|      |            |        |
|------|------------|--------|
| 31.0 | AN960JD416 | Washer |
|------|------------|--------|



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

| Qty | Part Number | Description | Batch |
|-----|-------------|-------------|-------|
| 1   | AN960JD416  | Washer      |       |

M108161

M-L

08/12/24

(1X)

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

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Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

32.0

MS27039406

Screw



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description Batch

1 MS27039-4-06

Screw

M.109061

M-L

33.0

D2646

Aft Cap



Comment: Qty.: 1.0000 Each(s)/Unit Total : 1.0000 Each(s)

Pick:

Qty Part Number

Description

Batch

1 D2646

BLUE

Aft Cap

B43801

M-L

34.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

A/R Sikaflex-291

Sikaflex expiry date:

M110110

09/07

2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

3-Install MS27039-4-06 Screw as per DEO 9153

4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

A/R Sikaflex-291

Sikaflex expiry date:

M110110

09/07

6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch:

M109214

M-L 08/12/24

35.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

08.12.24

| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
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|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

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|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |
|      |      |                                  |                      |                                 |                |                           |                       |                          |

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## Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: 206 L HIGH GEAR SKIDTUBE

Job Number: 43468A

Part Number: D206642441

Job Number:



Seq. #:

Machine Or Operation:

Description :

36.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

PPP43469

8/10/29

(1X)  
SL

37.0

QC21

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

(1)  
207/01/05

MF 08-12-31

Job Completion



| W/O: |      | WORK ORDER CHANGES |  |    |      |     |                                     |                          |
|------|------|--------------------|--|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE   |  | By | Date | Qty | Approval<br>Chief Eng /<br>Prod Mgr | Approval<br>QC Inspector |
|      |      |                    |  |    |      |     |                                     |                          |
|      |      |                    |  |    |      |     |                                     |                          |

Part No: \_\_\_\_\_ PAR #: \_\_\_\_\_ Fault Category: \_\_\_\_\_ NCR: Yes No DQA: \_\_\_\_\_ Date: \_\_\_\_\_

Resolution: \_\_\_\_\_ Disposition: \_\_\_\_\_ QA: N/C Closed: \_\_\_\_\_ Date: \_\_\_\_\_

| NCR: |      | WORK ORDER NON-CONFORMANCE (NCR) |                                |                                 |                |                           |                       |                          |
|------|------|----------------------------------|--------------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC<br>Section A   | Corrective Action<br>Section B |                                 | Sign &<br>Date | Verification<br>Section C | Approval<br>Chief Eng | Approval<br>QC Inspector |
|      |      |                                  | Initial<br>Chief Eng           | Action Description<br>Chief Eng |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |
|      |      |                                  |                                |                                 |                |                           |                       |                          |

**NOTE:** Date & initial all entries



| QTY<br>-1 | QTY<br>-3 | QTY<br>-5 | QTY<br>-7 | PART NUMBER   | DESCRIPTION   |
|-----------|-----------|-----------|-----------|---------------|---|
| X         |           |           |           | D2650-1       | SKIDTUBE ASSEMBLY                                       |
|           | X         |           |           | D2650-3       | SKIDTUBE ASSEMBLY                                       |
|           |           | X         |           | D2650-5       | SKIDTUBE ASSEMBLY                                       |
|           |           |           | X         | D2650-7       | SKIDTUBE ASSEMBLY                                       |
| 1         | 1         | 1         | 1         | D2600-1-160   | EXTRUSION   |
| 1         |           |           |           | D2654-1       | WEB   |
|           | 1         |           |           | D2654-3       | WEB   |
|           |           | 1         |           | D2654-5       | WEB   |
|           |           |           | 1         | D2654-7       | WEB   |
| 1         | 1         | 1         | 1         | D2646         | AFT CAP   |
| 1         | 1         | 1         | 1         | D2647         | CAP   |
| 17        | 18        | 19        | 23        | D2649         | CROSS BOLT SPACER                                       |
| 16        | 18        | 14        | 22        | D2651-1       | PLUG  |
| 16        | 18        | 14        | 22        | D2651-3       | O-RING  |
| 1         | 1         | 1         | 1         | D2680-041     | NUT PLATE   |
| 2         | 2         |           |           | D3286-1       | DOUBLER   |
| 2         | 2         |           |           | D3286-3       | STUD  |
| 42        | 44        | 54        | 60        | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2         | 2         | 2         | 2         | AN960JD10L    | WASHER  |
| 2         | 2         | 2         | 2         | CCR264SS3-3   | RIVET   |
| 2         | 2         | 2         | 2         | CR3212-4-03   | RIVET   |
| 2         | 2         | 2         | 2         | MS27039-1-08  | SCREW   |
| 1         | 1         | 1         | 1         | MS27039-4-06  | SCREW   |
| 1         | 1         | 1         | 1         | AN960JD416    | WASHER  |
| 52        | 52        |           |           | CR3212-4-04   | RIVET   |

F

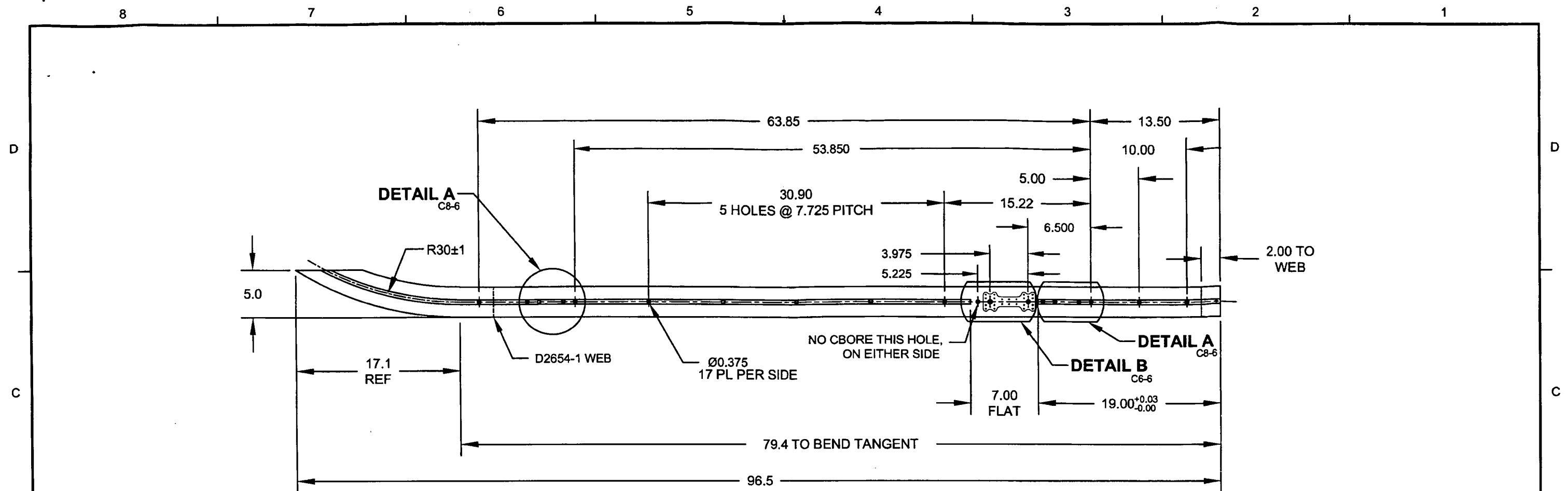
# NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1  
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3  
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:  
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

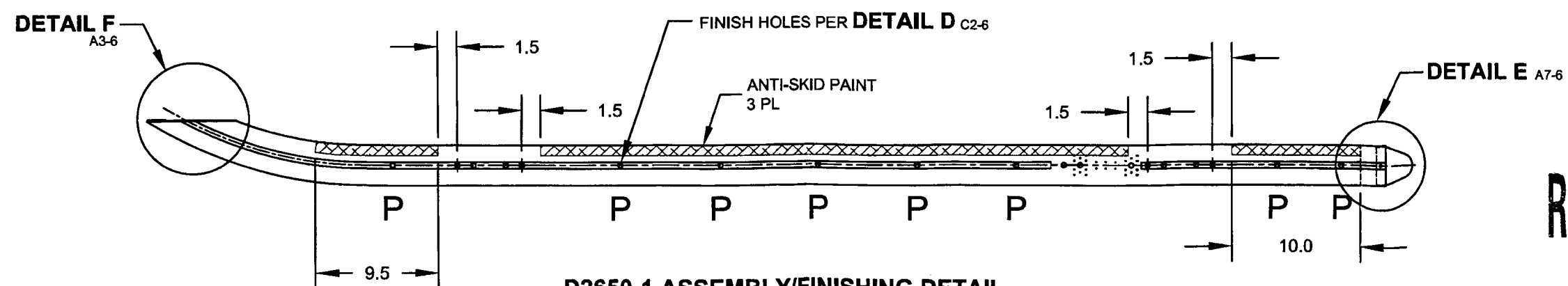
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|            |   |  |              |
|------------|---|--|--------------|
| F          | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS  | 08.08.08     |
| E          | RMOVE CBORE, CHG DRILL, ADD CHAMFER   | CP   | 06.03.30     |
| D          | REDRAW; INCCRP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3   | CP   | 04.05.17     |
| C          | CHANGE HOLE PATTERN AND FRONT END   | DS   | 97.10.29     |
| B          | AS MANUFACTURED CHANGES   | DS   | 97.06.26     |
| A          | NEW ISSUE   | DS   | 97.03.25     |
| REV.       | DESCRIPTION   | BY   | DATE         |
| DESIGN     | DS  | DART AEROSPACE USA, INC  |              |
| DRAWN      | AJS   | PORT HADLOCK, WA   |              |
| CHECKED    |   | DRAWING NO.  | REV. F       |
| MFG. APPR. |   | D2650  | SHEET 1 OF 6 |
| APPROVED   |   | TITLE  | SCALE        |
| DE APPR.   |   | 206/407 SKIDTUBE ASSEMBLIES  | NTS          |
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### D2650-1 BENDING/DRILLING DETAIL



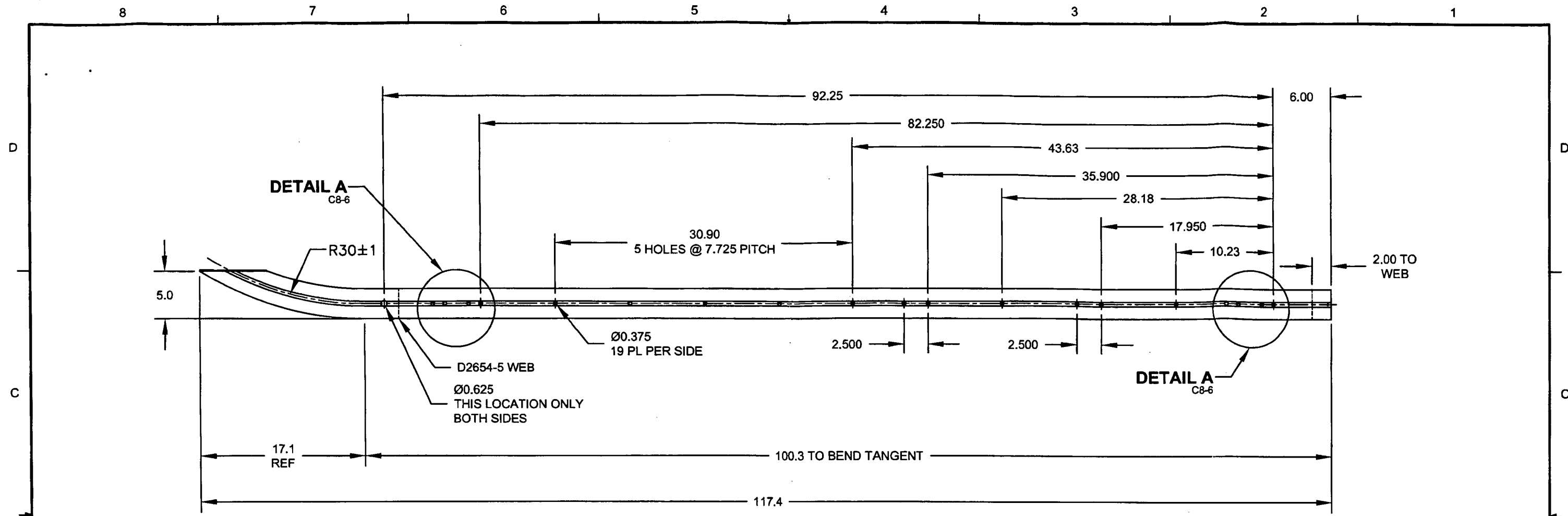
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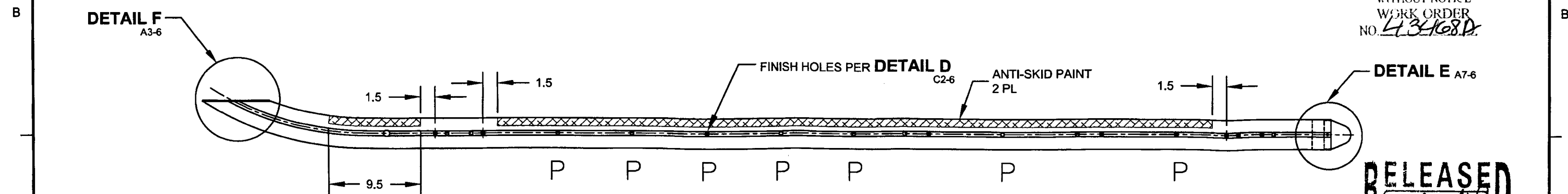
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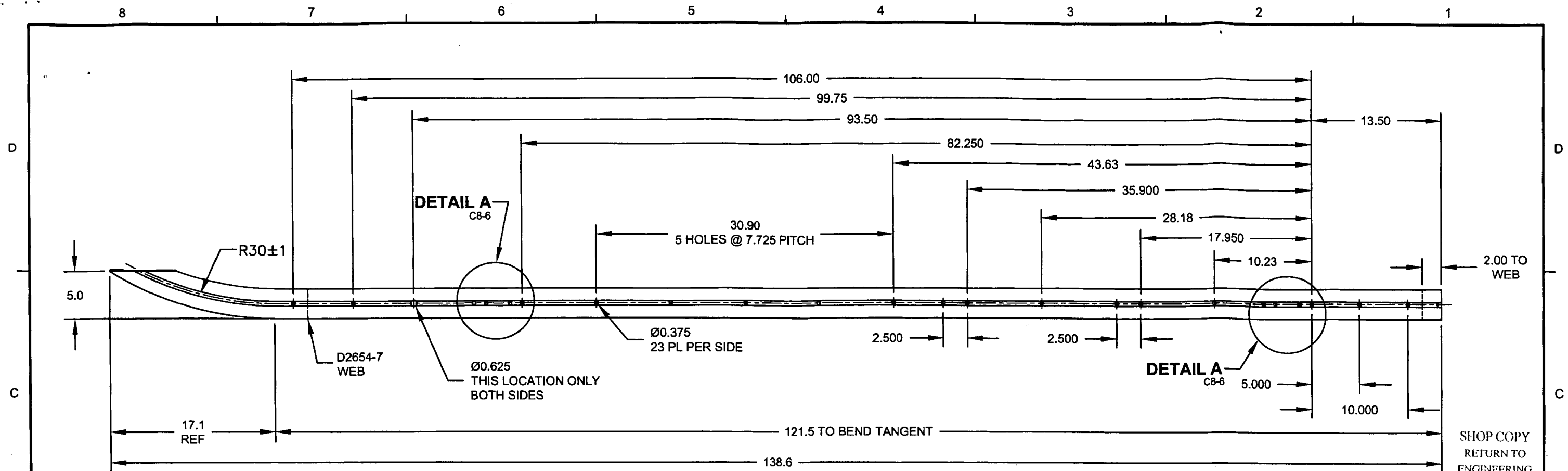
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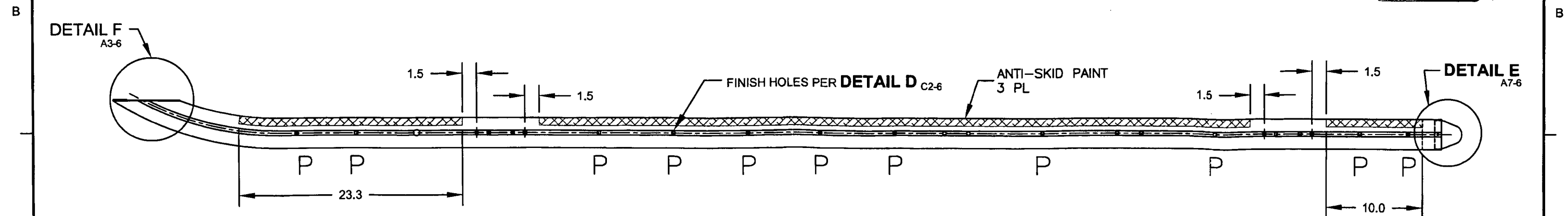
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|---|---|---|--------------|
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| DRAWN   | AJS   | PORT HADLOCK, WA                            |              |
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| MFG. APPR.  |  | D2650                                       | SHEET 4 OF 6 |
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**D2650-7 BENDING/DRILL DETAIL**

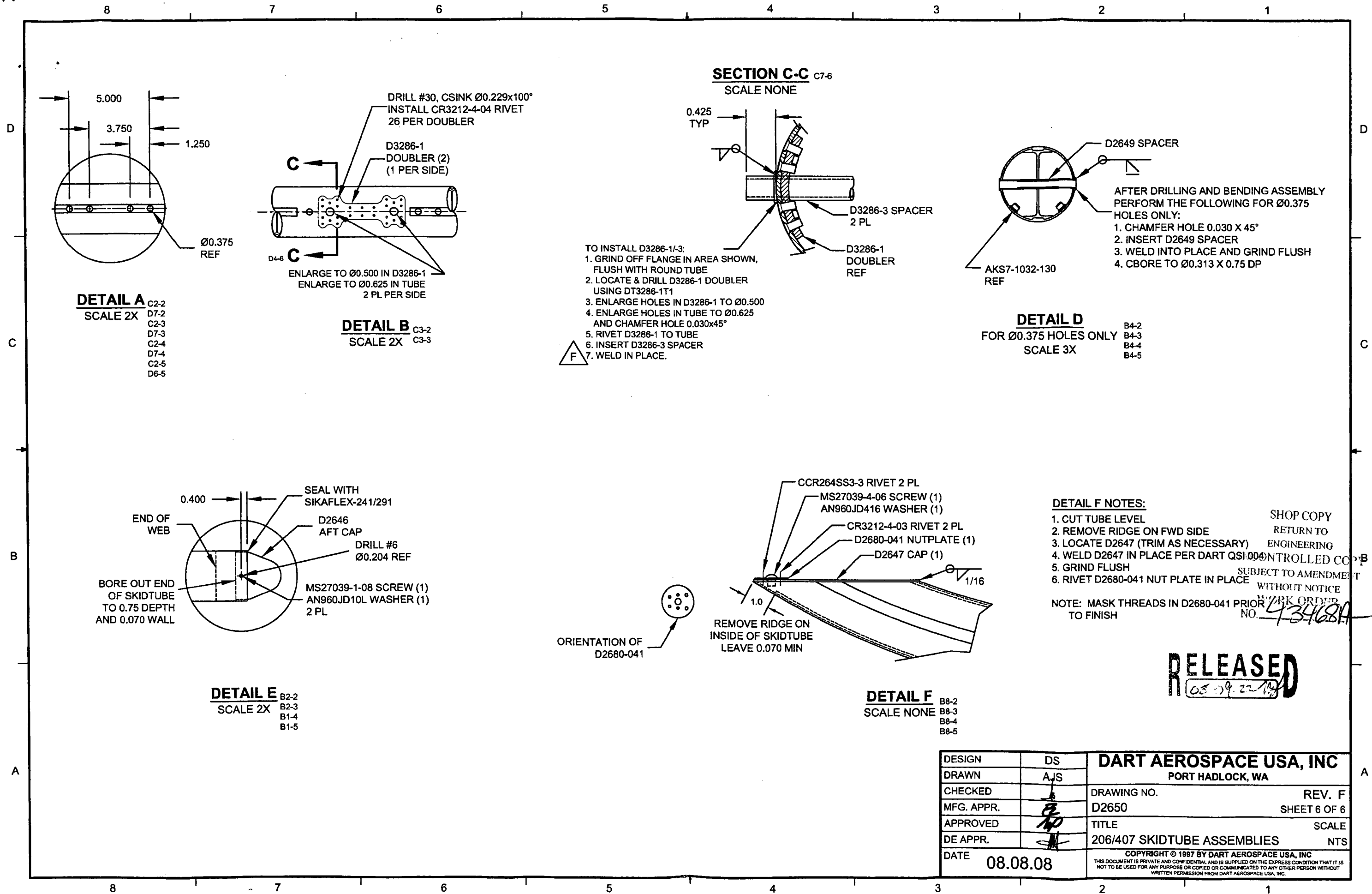
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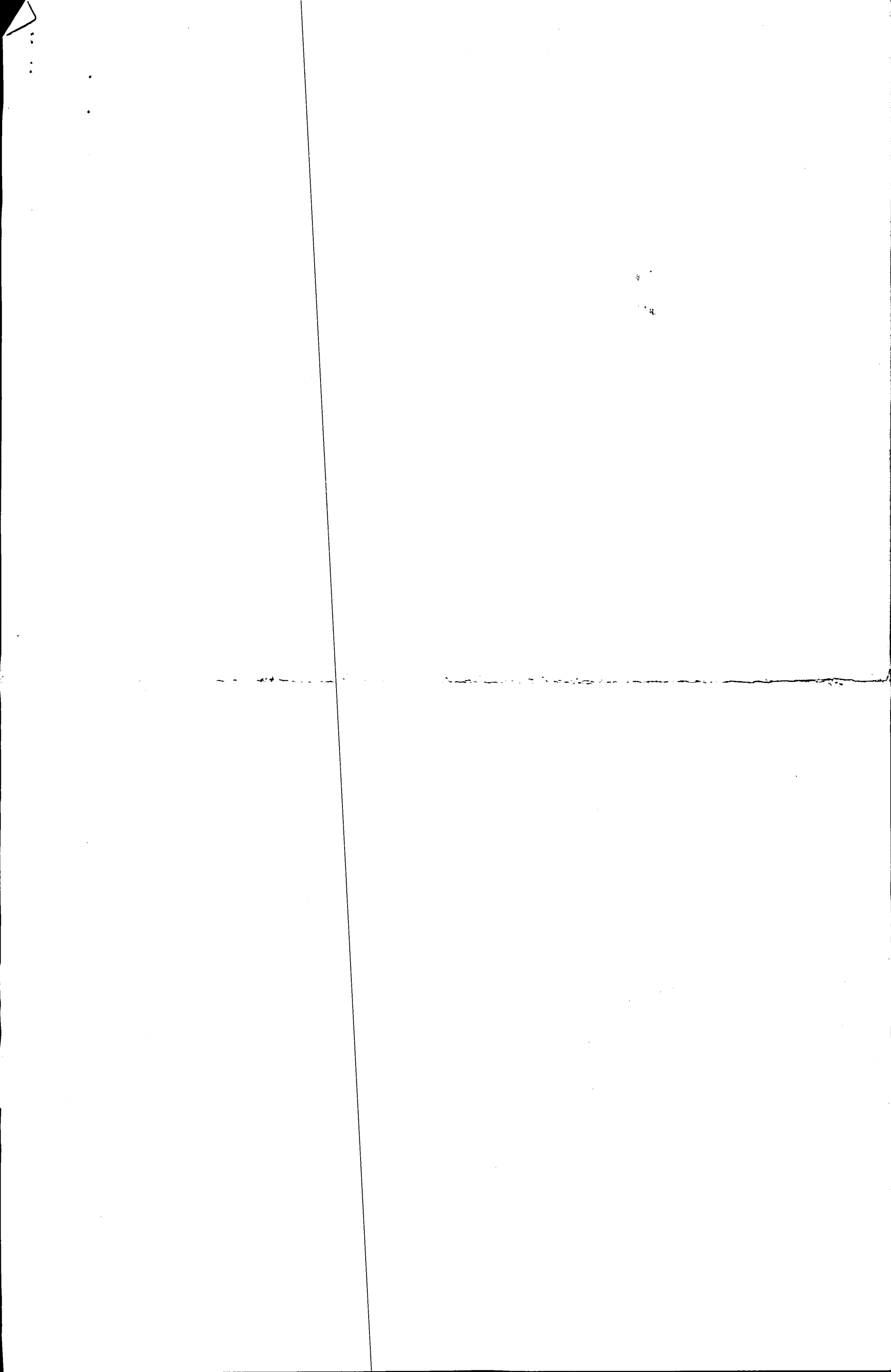
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| MFG. APPR. |          | D2650  | SHEET 5 OF 6 |
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NO. 180

AWS D17.1.2001  
QUALIFICATION TEST RECORD

Name: Barclay Elliot  
Job number: B42582 A  
Part number: A206-642-441  
Description: 206 Skid tube  
Welding Process: Tig[☒] Mig[ ]  
Base material: Alum  
Current: AC[☒] DC[ ]

**TEST REQUIREMENTS AND RESULTS**

Visual: pass[☒] fail[ ]  
Penetration: pass[☒] fail[ ]

**UNACCEPTABLE**

Cracks: pass[☒] fail[ ]  
Undercut: pass[☒] fail[ ]  
Pin holes: pass[☒] fail[ ]  
Overlap (cold lap): pass[☒] fail[ ]  
Porosity (surface): pass[☒] fail[ ]  
Coloration: pass[☒] fail[ ]

Qualifier David Druel Date of Test Coupon 08/10/30  
Welder Barclay Elliot Date of Test Coupon 08/10/30

The above named individual is qualified in accordance with AWS D17.1.2001 to weld